



Dart Aerospace Ltd.
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D3391-023**Job Sheet 171996****Part No:** D3391-023**Job Qty:** 1 ea**Part Name:** Mid Tube Assembly**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 2/12/18**Job Tracking No:****Due Date:** 2/23/18**Created By:** Michelle Gagnon-Donovan**Type:** SOLD**Description:**

Note: DWG REV J SHEET 7 IPP A 05.10.20 New Issue KJ/EC IPP B IPP C 07.03.20 rev F dwg EC IPP D 07.03.28 re-format EC IPP E 07.10.31 ecn 1053P EC IPP Rev:F ECN 1056 07-11-13 DD verified by: EC IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC IPP Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP Rev:J add in seq 140 expire date &b# sikaflex DD 10.02.17 verified by:EC

Ship Via:**Bill of Materials**



Container No: S042655



Part: D3391-023

Serial No/Batch: S042655

Revision: D3391

Inspector:

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Date: 02/15/18 13:02 PM

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/22/18	0.00	0.00	Start Up Skid tubes-1		
100	Skid tubes	1 pcs		2/22/18	0.88	2.11	Skid tubes-4		
110	QC	1 pcs		2/22/18	0.00	0.00	QC5		
120	HandFinish	1 pcs		2/22/18	0.00	0.38	HandFinish1		
130	QC	1 pcs		2/22/18	0.00	0.00	QC7-2		
140	Skid tubes	1 pcs		2/22/18	0.00	2.11	Skid tubes-4		
150	QC	1 pcs		2/22/18	0.00	0.00	QC5		
160	Skid tubes	1 pcs		2/22/18	0.00	2.11	Skid tubes-4		
170	QC	1 pcs		2/22/18	0.00	0.00	QC10		
180	QC	1 pcs		2/22/18	0.00	0.00	QC5		
185	HandFinish	1 pcs		2/22/18	0.00	0.38	HandFinish2		
191	SprayPaint	1 pcs		2/22/18	0.00	0.91	Spray Paint		
192	Outsource	1 pcs		2/22/18			ATE003-VC		
193	Packaging	1 pcs		2/22/18	0.00	0.00	Packaging2		
200	QC	1 pcs		2/22/18	0.00	0.00	QC14		
230	HandFinish	1 pcs		2/23/18	0.00	0.38	HandFinish4		
240	QC	1 pcs		2/23/18	0.00	0.00	QC5		
250	Packaging	1 pcs		2/23/18	0.00	0.00	Packaging3-1		
260	QC21-SA	1 Ea		2/23/18	0.00	0.00	QC21		

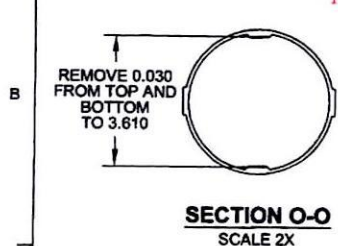
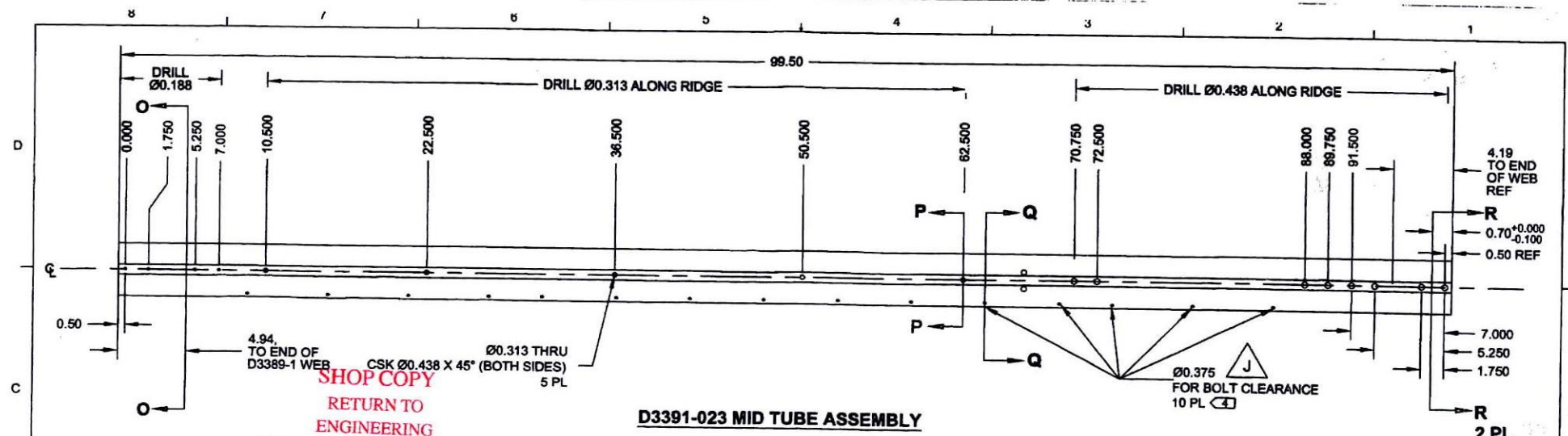
Part Op 100 - 1-Cut tube to finish length as per Dwg D3391 2-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1
 Descriptions: fwd saddle hole on one side only as per Dwg D3391 3-Open aft saddles and GHW holes to Ø0.4375" except for fwd saddle
 holes 4-Remove .030" from Fwd indexing Ridge as per Dwg D3391 5-Remove indexing ridge on Fwd & Aft end of
 skid tube as per Dwg D3391 6-Deburr, scribe batch # on aft end. 7-~~Locate D3391-021 in D3391-023 at 9.00" (see view F-
 F) 8-Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149
 locating from previously drill .188" dia hole, using t-pins and clamps to ensure perfect alignment, open up previously transfer
 drilled pilot holes in D3391-023/021 using drill press. ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to
 0.500" as per ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499"-D3391-021~~
 BATCH: 9- Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.375" holes with paint marker,
 DO NOT DRILL HOLES #3-19-20 FROM FWD END OF JIG Locating from two fwd wearplate holes in D3391-023
 drill remaining 6 wearplate holes in D3391-021 using DT8937 10- Open wearplate holes of D3391-023 assembly detail
 section Q-Q to Ø0.375" (10 holes) as per Dwg D3391 Open wearplate holes of D3391-023 assembly detail section H-H to
 Ø0.297" (20 holes) as per Dwg D3391 Deburr and blow out all chips from inside tube, scribe
 140 - 1-Open float bag holes as per dwg 2-C'sink float bag holes as per dwg 3- Prepare tube for welding 4-Bond web in
 place as per Dwg D3391 & QSI 015. Adhere for 12 hours) A/R Sikaflex exp: 18-04-21 batch#: m138 654
 NOTE:ENSURE WEB IS INSERTED IN AFT END OF TUBE
 160 - 1-Weld crossbolt spacer as per dwg D3391 & QSI 004 2-grind weld flush A/R m138673
 185 - Re-alodine
 191 - PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 138687 PAINT AS PER DWG AND
 QSI005 4.2.2.4 PAINT: 138741
 230 - 1-Install Inserts as per Dwg

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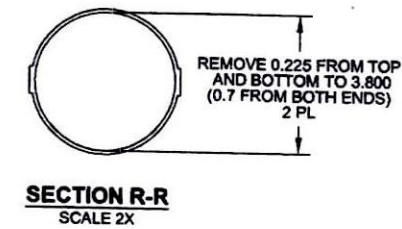
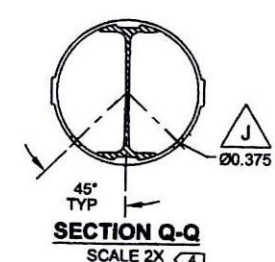
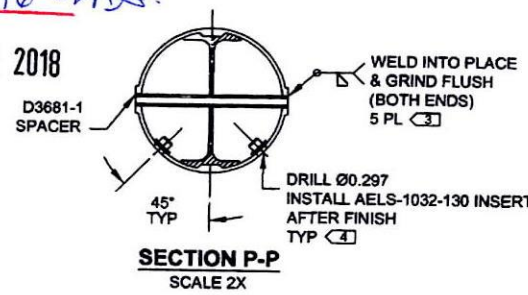
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2500-1-100	Skid tube Extrusion	1 Ea (1 ea)	90-Start up Operation	
D3389-1	Web	1 Ea (1 ea)	140-Skid tubes	
D3681-1	Spacer	5 Ea (5 ea)	160-Skid tubes	
ALS4-1032-130	Rivnut	20 Ea (20 ea)	230-HandFinish	
D3591-1	Bushing	2 Ea (2 ea)	230-HandFinish	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-1-100	1	70	0
140-Skid tubes	D3389-1	1	9	0
160-Skid tubes	D3681-1	5	381	0
230-HandFinish	ALS4-1032-130	20	8,687	0
	D3591-1	2	75	0

Part Specifications	
Specifications could not be found.	



FEB 12 2018



D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT



D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004
- 4) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES, CBORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.		D3391	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	16.01.14	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC	

RELEASED
2016-04-28